

Work Order ID 56530

March 1, 2010 9:30:31 AM

Page 1

Item ID: D2857-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Hinge Bracket

Start Date: 3/01/10

Start Qty: 24.00

Required Date: 3/08/10

Req'd Qty: 24.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2857

Rev B

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks 5.2"

0.00

0.00

H.A 10/03/01

20 0

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio D2857-2112-Deburr any rough edges

0.00

0.00

ref 10.3.7

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

ref 10.3.7

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56530

March 1, 2010 9:30:31 AM



Page 2

Item ID: D2857-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 3/01/10

Start Qty: 24.00



Cust Item ID:

Required Date: 3/08/10

Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

L.P. 10/03/08

20

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

MS 10/03/08

(X20)

0

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

S. 10/03/08

counter

(X20)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56530

March 1, 2010 9:30:32 AM



Page 4

Item ID: D2857-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 3/01/10 Start Qty: 24.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 24.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/11 *[Signature]*

mf

10-3-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 1, 2010 9:30:30 AM

Page 1

Work Order ID: 56530



Parent Item: D2857-2



Parent Item Name: Hinge Bracket

Start Date: 3/01/10

Required Date: 3/08/10

Comments: IPP [C]00.06.22[]Removed P/O for powder coat[]EC[]
IPP [D]06.03.30[]Added level 8 []EC[]

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	27.5655	11.0526			



6061-T6 Bar 2.00 x 1.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

27.56546842

105838

6.9124

110936

0.00036842

113608

20.6527

9.1000 ft

M.A 10/03/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

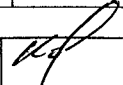
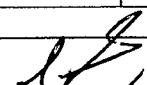
NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order: 56530
Description: Hinge Bracket		Part Number: D2857-1
Inspection Dwg: D2857	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.300	/			
4.000	+/-0.010	4.000	/			
0.340	+/-0.010	.335	/			
1.110	+/-0.005	1.113	/			
1.790	+/-0.010	1.791	/			
1.320	+/-0.005	1.320	/			
2.000	+/-0.010	2.000	/			
0.340	+/-0.010	.340	/			
0.447	+/-0.010	.447	/			
Ø0.171	+0.005/-0.000	.171	/			
0.147	+/-0.010	.148	/			
0.376	+/-0.010	.375	/			
0.126	+/-0.010	.127	/			
0.063	+/-0.010	.063	/			
Ø0.166	+0.005/-0.000	.166	/			
0.911	+/-0.010	.911	/			
0.600	+/-0.010	.600	/			
0.125	+/-0.010	.125	/			
0.150	+/-0.010	.147	/			

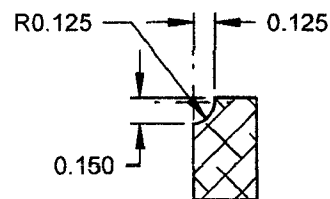
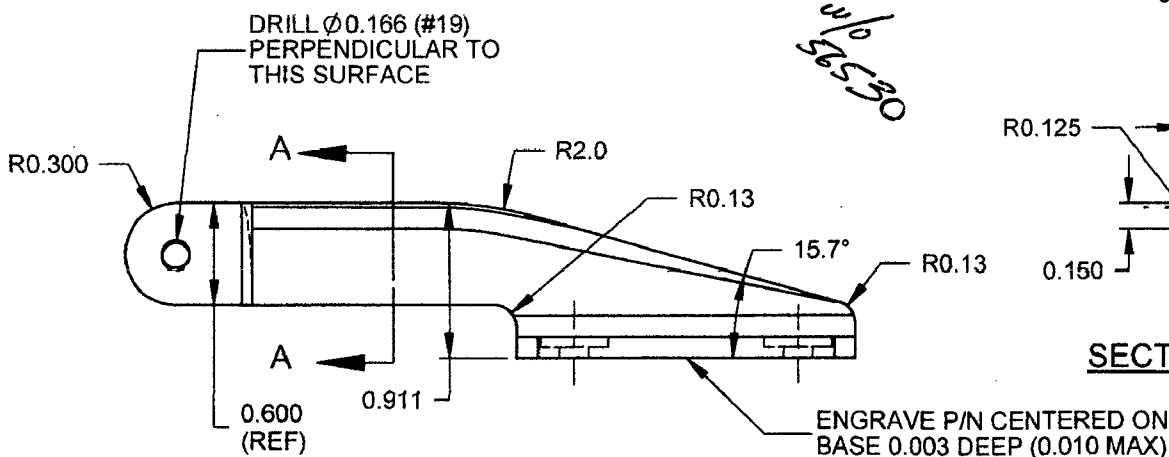
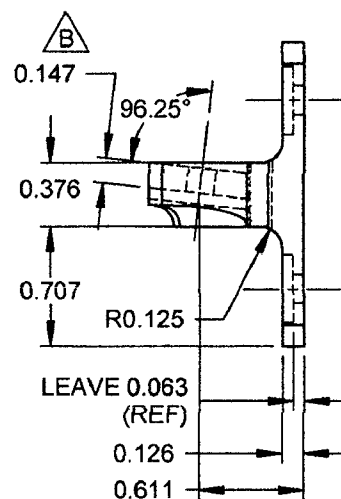
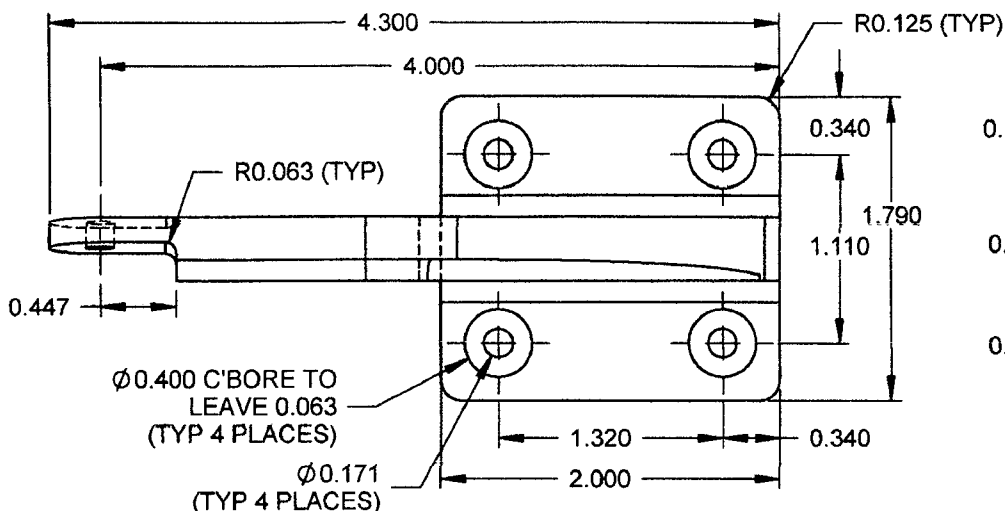
Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 10.3.7	Date: 10/03/7	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	



DESIGN KE	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28		TITLE HINGE BRACKET	SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

RELEASED
06 10 13

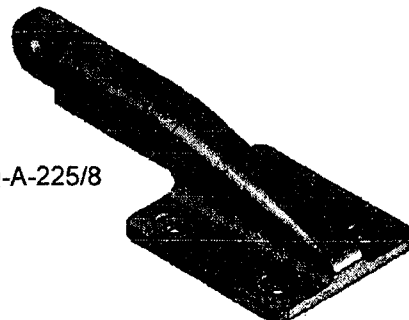


SECTION A-A

D2857-1 HINGE BRACKET
D2857-2 OPPOSITE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



COPYRIGHT © 1998 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.